

Work Order ID 152264

Friday, October 21, 2016 3:03:16 PM

152264

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Item ID: D4950-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Tailboom Mount
 Start Date: 10/19/2016 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 10/21/2016 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: **DAS 21 9-89** Date: **OCT 26 2016** Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4950	B								

100
100 Small Fab 0.00
 Small Fab Memo 0.00
 Small Fab 1- Assemble with a thin layer of Proseal between the mating surfaces as per dwg D4950
 A/R Proseal 890 batch: **135390** **DAS 36 9-89**

110
110 QC 0.00
 Quality Control Memo 0.00
DAS 38 9-89
NOV 11 2016

113
113 SprayPaint 0.00
 Spray Painting Memo 0.00
 Prime as per dwg and OSI
 A/R Primer Batch: **135654** **DAS 41 9-89**
16-11-12

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
							Completed By		
							Lead hand / Supervisor Approval Verification		
							QC / QA Coordinator Approval		

Root Cause				FAULT CATEGORY							
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence	☐
Past Expiry Date	☐	Manufacturing Process	☐	OTHER : _____							
Misidentified	☐	Past Due	☐								

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
115 *115* QC Quality Control	QC14- Inspect Spray Paint Memo	0.00 0.00				1			DAS 38 9-89 NOV 14 2016
120 *120* Packaging Packaging	Identify as per dwg & Stock Location: 85/139 Memo	0.00 0.00				1 X			DAS 26 9-89 NOV 14 2016
130 *130* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							DAS 21 9-89 NOV 14 2016 DAS 21 9-89 NOV 14 2016

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Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
Misidentified ☐	Past Due ☐				

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D4950-041

Required Date: 10/21/2016

Required Qty: 1.00

Comments: IPP REV:A 13.09.24 NEW ISSUE DD VERF:JLM
REV:B 14.01.16 AS PER DWG REV.B DD VERF:JLM IPP

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4950-1		Manufactured	No		51139		Each	0.0000		1			
D4950-1 Mount													
D3868-1		Manufactured	No				Each	21.0000		2			
D3868-1 Spacer													
DAS 36 9-89 Location ST056 111657 Loc Qty 21 21 Loc Code 2													
MS20426AD3-6		Purchased	No				Each	2,848.000		4			
MS20426AD3-6 Rivet													
DAS 6 9-89 Location GA M133988 ST312 M133988 Loc Qty 1864 1864 984 984 Loc Code 11533													

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



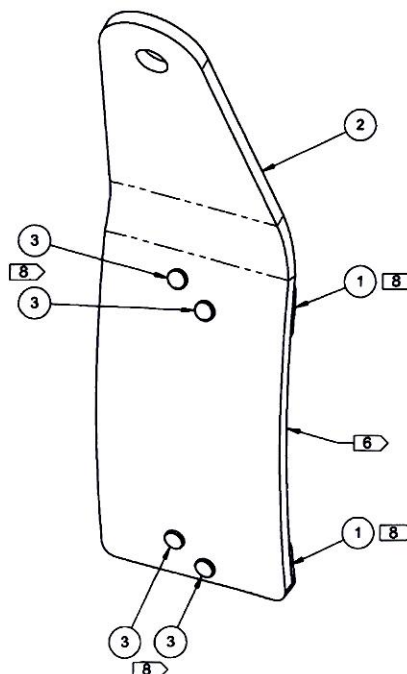
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Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish	☐
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ITEM NO.	QTY -041	PART NUMBER	DESCRIPTION
	X	D4950-041	TAILBOOM MOUNT
1	2	D3868-1	SPACER
2	1	D4950-1	MOUNT
3	4	MS20426AD3-6	RIVET



D4950-041 TAILBOOM MOUNT

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 152264
Em 16/11/11

RELEASED
2014-01-15

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: PRIME ASSEMBLY PER QSI 005
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4950-041" AND B/N PER DART QSI 044 6.1 (FINE POINT PAINT MARKER)
 - 7) WEIGHT: 0.36 lbs
 - 8) APPLY A THIN LAYER OF PROSEAL 890 BETWEEN THE MATING SURFACES OF D3868-1 AND D4950-1 AND INSTALL RIVETS WET



B	MATL FOR D4950-1/3 WAS 6061-T6 (ZN AS-4/6); REDESIGNED D4950-1F/3F 0.25 LONGER (ZN BS-4/6); ADD NOTE 8 (ZN A4-1/2). REASON: PAR13-318.	MB	13.12.11
A	NEW ISSUE	MB	13.09.23
REV.	DESCRIPTION	BY	DATE
DESIGN	DB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	MB		
CHECKED	AP	DRAWING NO.	REV. B
MFG. APPR.	DD	D4950	SHEET 1 OF 6
APPROVED	MP	TITLE	SCALE
DE APPR.	DS	MOUNT	NTS
DATE	14.01.09	COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

APPROVED